

Date: Thursday, 10/07/2008 3:11:26 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	40430			Part Number	: D35645		
Estimate Number	12786			Drawing Number	: D3564 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	10/07/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	: 28/07/2008		
Previous Run	39573			Qty:	20	Um:	Each
Written By	:						
Checked & Approved By	: JYL 08-7-10						
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC Est Rev D added DT# 08.04.21 DD Verified by EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 1.5750 sf(s)/Unit Total : 31.5000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 108156 X 12 = LB 8-7-17		
2.0	WATER JET 108090 X 1	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: B (LB 8-7-17) Prog Rev: D B 2-Deburr if necessary LB 8-7-17		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE LB 8-7-17		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK S 08/07/13		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 SB 08/07/20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/07/2008 3:11:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 40430

Part Number: D35645

Job Number:



Seq. #: Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT8157

EPD08/07/25 13X

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/07/25 x13

7.0 POWDER COATING

POWDER COATING



M106442

13X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

9:30 OF

OVEN TEMPERATURE:

320°

FINISH TIME:

10:00

M/L 08/07/26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-28

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-19*

BL 08-07-28

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/08

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40430
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

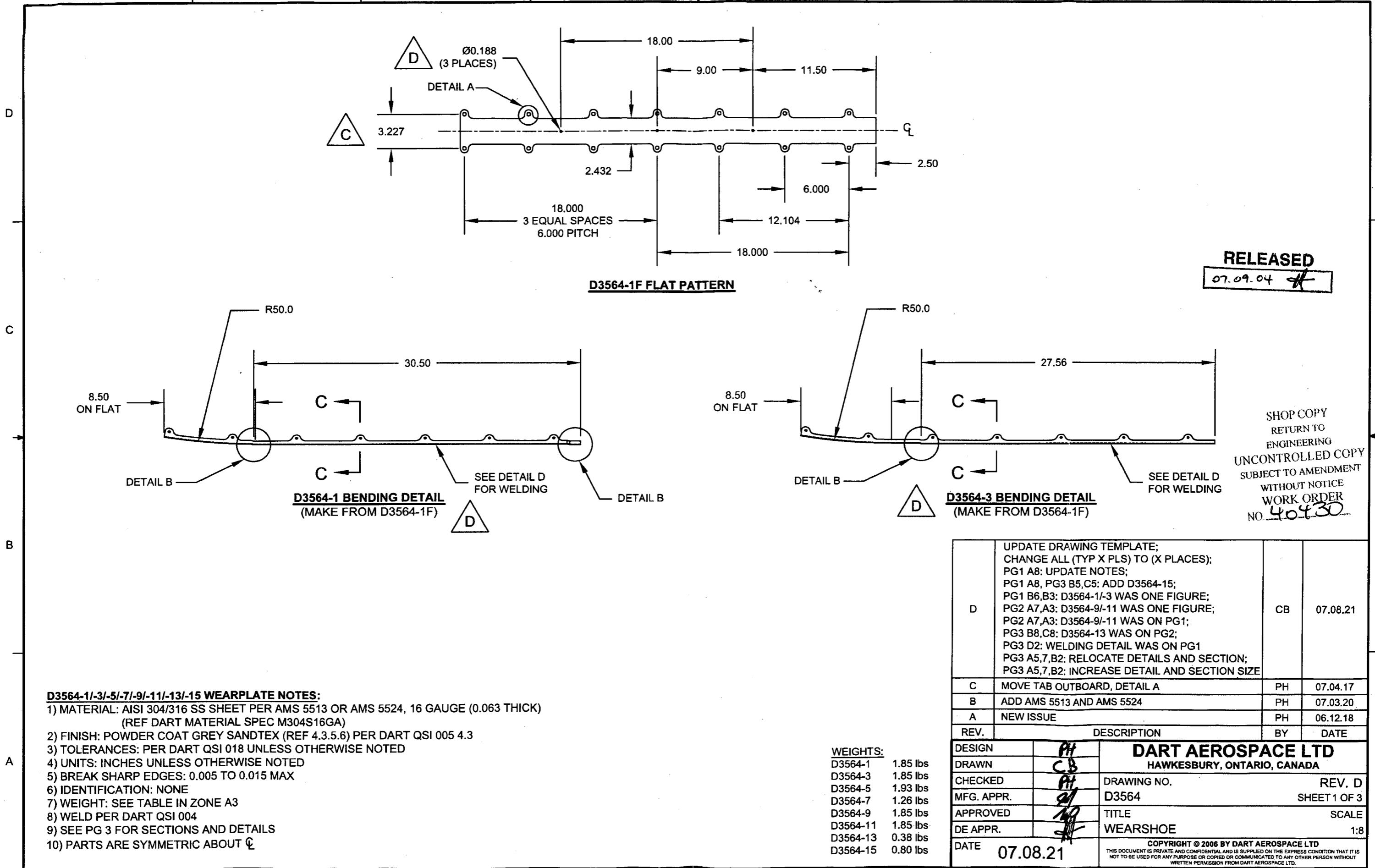
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BR</u>	Audited by:	<u>CD</u>	Prototype Approval:	N/A
Date:	8-7-17	Date:	08/07/17	Date:	N/A

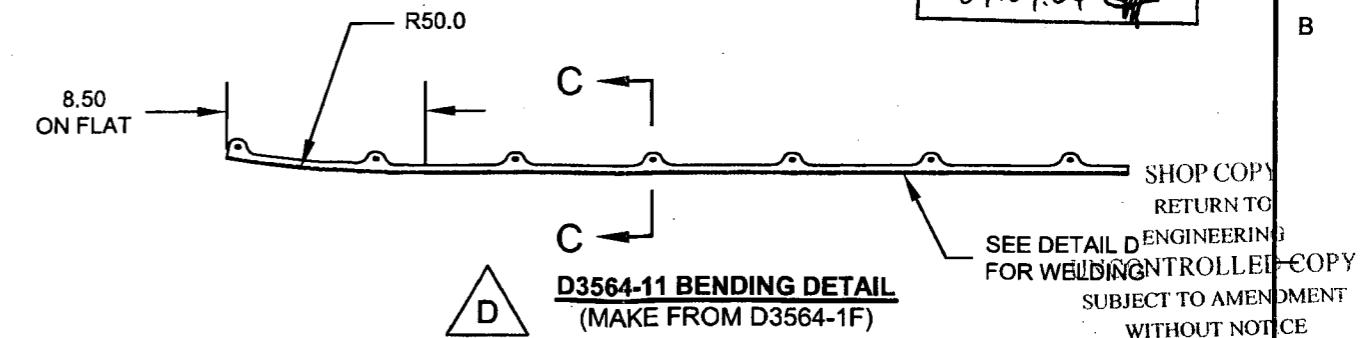
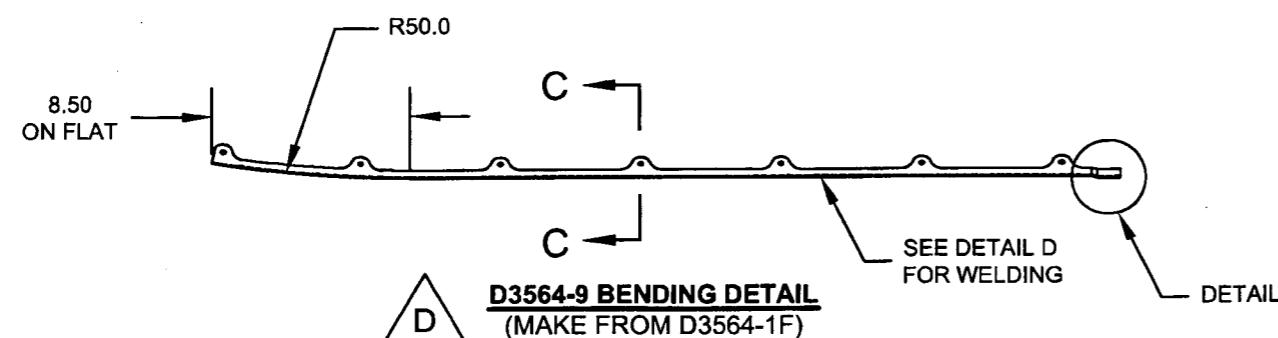
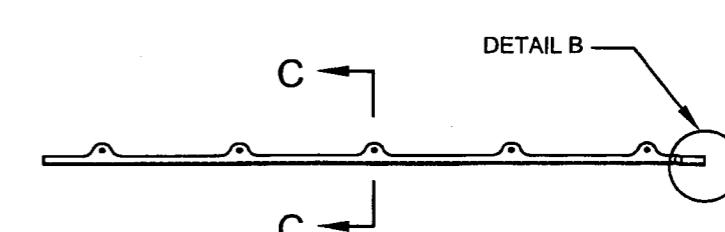
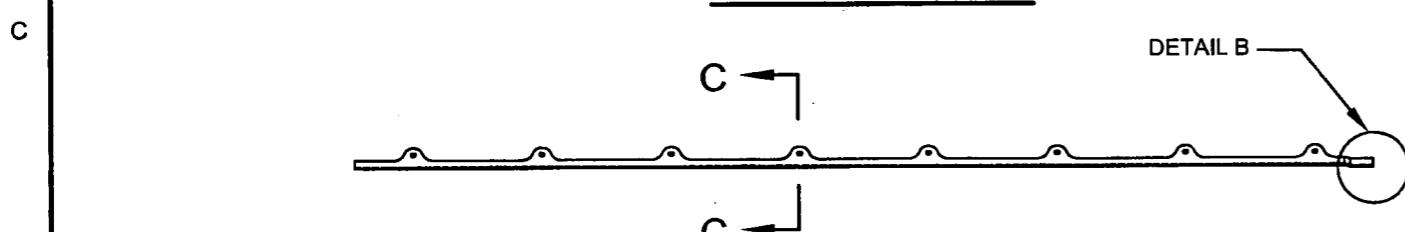
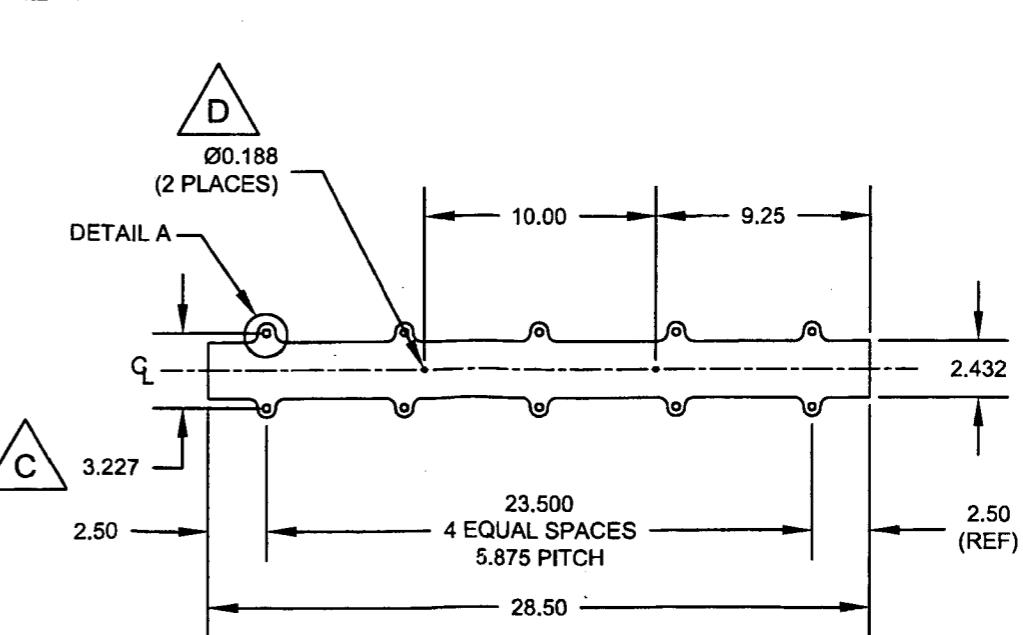
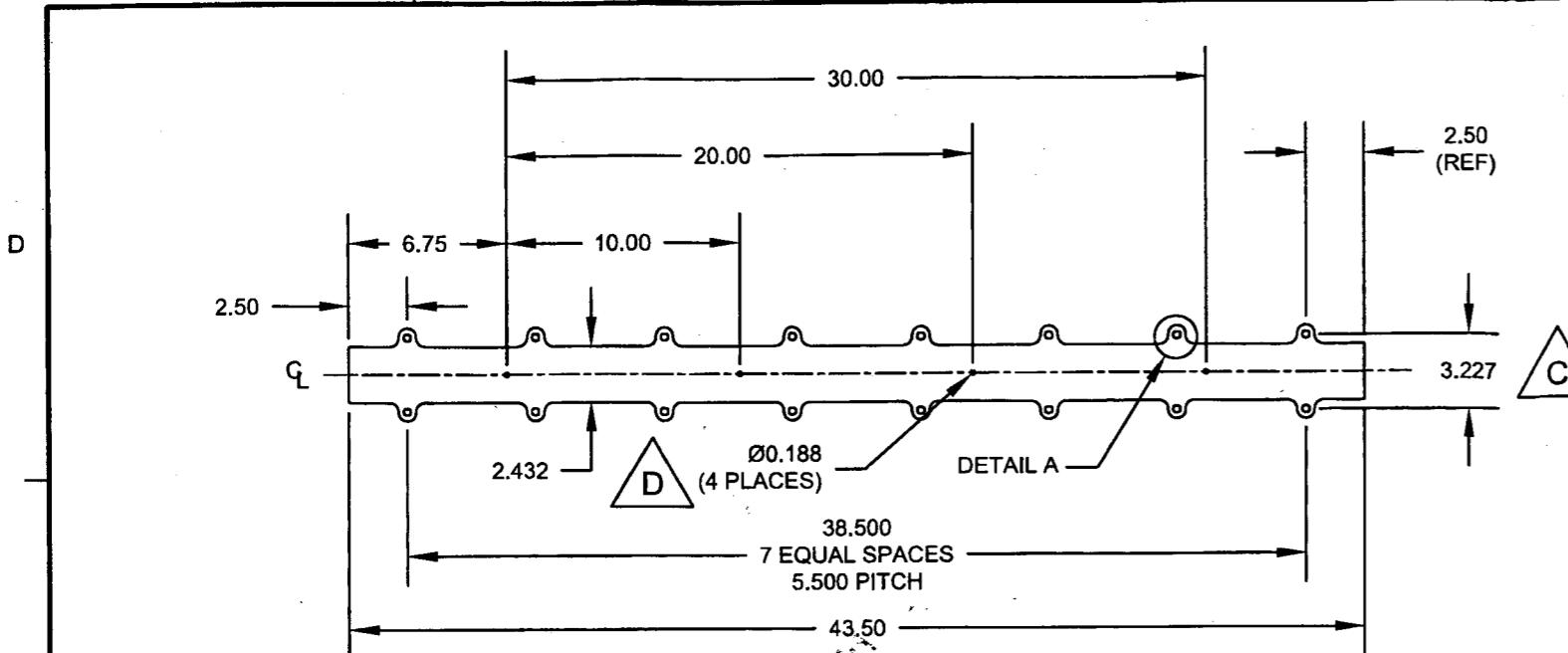
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	BB

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



RELEASED

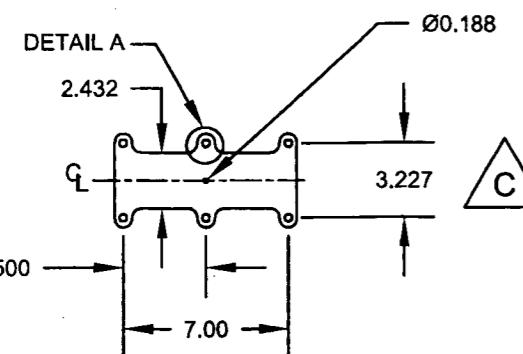
07.09.04

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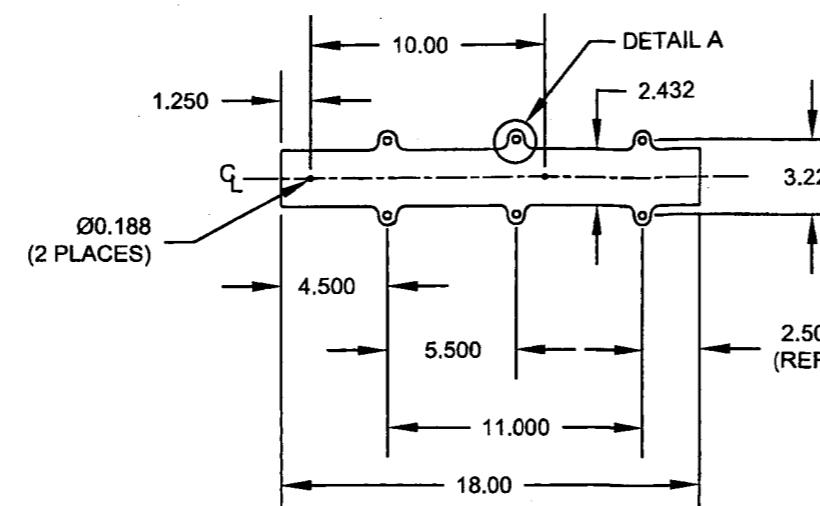
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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA			
CHECKED	PH	DRAWING NO.			
MFG. APPR.	SI	REV. D			
APPROVED	NO	D3564			
DE APPR.	SI	SHEET 2 OF 3			
DATE	07.08.21	TITLE			
		WEARSHOE			
		SCALE			
		1:8			
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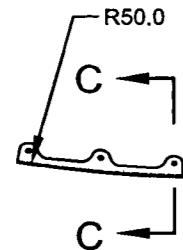
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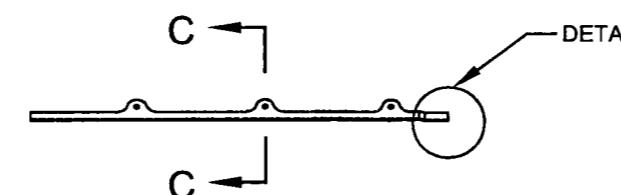
D3564-13F FLAT PATTERN



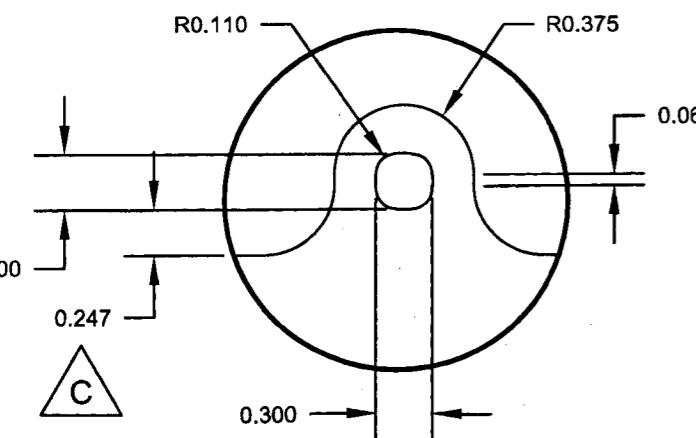
D3564-15F FLAT PATTERN



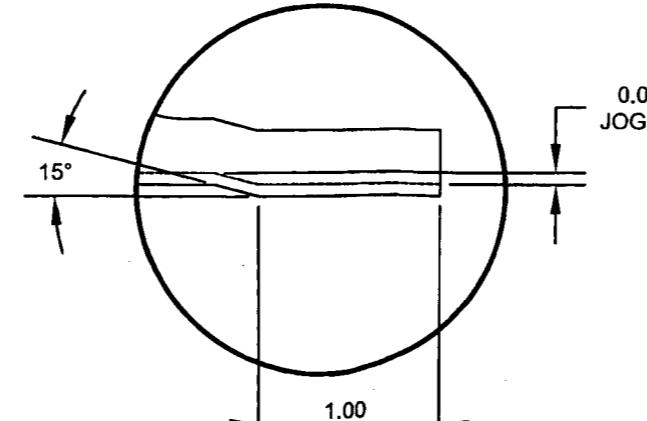
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

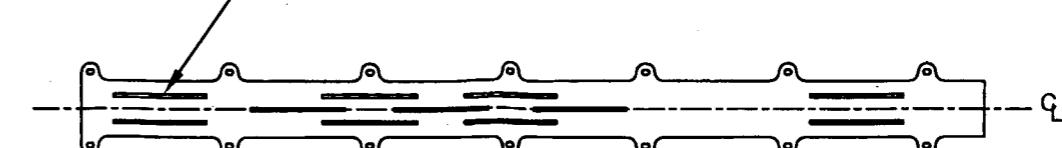


DETAIL A
SCALE 1:1



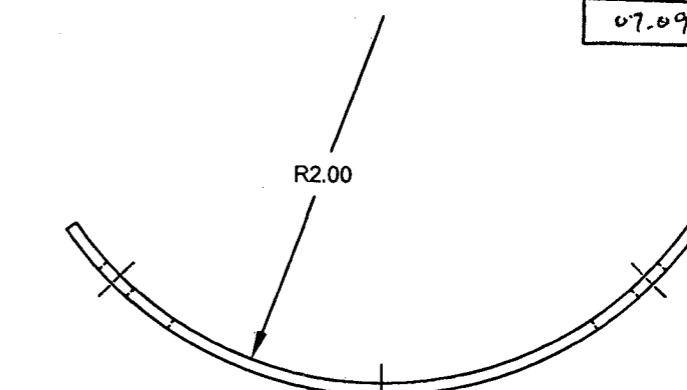
DETAIL B
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



DETAIL D
(D3564-1/3-9/11 WELDING DETAIL)

RELEASED
07.09.04



SECTION C-C
SCALE 1:1

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DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKSLEY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	SI	D3564
APPROVED	SI	REV. D
DE APPR.	SI	SHEET 3 OF 3
DATE	07.08.21	TITLE
		WEARSHOE
		SCALE
		1:8

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8 7 6 5 4 3 2 1

